

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003422**Date Inspected:** 15-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Ken Jobes, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, to randomly monitor welding and Quality Control (QC) functions. While on site, the QA Inspector observed and/or discovered the following:

Tower (Heavy Machinery Shop – Bay 1

The Caltrans QA Inspector randomly observed the Submerged Arc Welding (SAW) of fill passes on Weld No. SSD1-SA179 B/E-1A in the flat groove (1G) welding position. The welding operator was Xu Xia Shui (I. D. No. 040489) and the Welding Procedure Specification (WPS) No. was WPS-B-T-2221-B-U3c-S-2. ZPMC Certified Welding Inspector (CWI), Liu Hua jie (CWI No. 07120741), was present during the welding, as was ABF QA Inspectors, Xiao Jun Peng and Jiang Zi wen. The Caltrans QA Inspector verified the qualifications of the welding operator, and that the electrode classification, diameter of electrode, amperage, voltage, travel speed, and preheat/interpass temperatures were within the specified ranges on the applicable WPS.

No machining or flame cutting was being done in this shop.

Tower (Heavy Machinery Shop – Bay 2

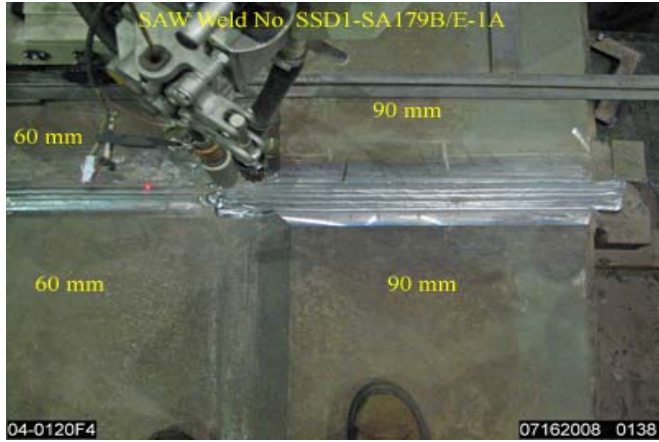
The Caltrans QA Inspector randomly observed flame cutting at two work stations. Miscellaneous parts were being flame cut at one work station and a tower diaphragm plate at another work station. Also, at the second work station, ZPMC personnel were observed verifying dimensions on the tower diaphragm plate being cut

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No machining or welding cutting was being done in this shop.

All above observations appeared to meet the requirements of the job specifications.



Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Tower - Joshua Ishibashi (13764710411) China, who represents the Office of Structural Materials for your project.

Inspected By:	Jobes, Kenneth	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer
